

NCL-19-7587



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

②

D206-667-103TRN
Job Sheet 196495



Part No: D206-667-103TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 6/27/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 removed polish EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	1 pcs	6/27/19	6/27/19	1.00	2.10	Mori Seiki TL-40 - 1		662019-06-19
110	QC 2	1 pcs	6/27/19	6/27/19	0.00	0.00	QC 2 - 1		9-89
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		DAS
							QC 2 - 66		662019-06-19
							QC 2 - 64		9-89

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P.T.O.

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	6/27/19	1.00 2.10	Mori Seiki TL-40 - 1 - B4B	DAS 662019-06-20
130	QC 2	1 pcs	6/27/19	0.00 0.00	QC 2 - 1	9-89
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS
					QC 2 - 66	662019-06-20
					QC 2 - 64	9-89
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	1 pcs	6/27/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	60/00/19-07-25

					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
145	Crosstubes - 2 - B4B	1 pcs	6/27/19	0.00 0.59	Crosstubes - 1 - B4B	BB 7/27/2019
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
150	Crosstubes - 3 - B4B HANDFINISH	1 pcs	6/27/19	0.00 0.72	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	AUG 06 2019
					Crosstubes - 4 - B4B	
160	QC 7	1 pcs	6/27/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	DAS
					QC 7 - 67	67 19-08-07
					QC 7 - 40	9-89
					QC 7 - 24	
					QC 7 - 43	
170	Packaging 3-1 - Stock - B4B	1 pcs	6/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Plex 6/14/19 7:15 AM Dart.lajeunesse.marie	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	BSB 8/8/2019
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	6/27/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	53

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs DT8534 on both ends as per
 Descriptions: Folio FA087 2-Turn first side as per Folio FA087 3-Blend transition lines only, **do not sand whole tube**: FOLIO
 REV: _____ DWG REV: _____ *Use mill bastard file, brush file repeatedly with file card. *Do not use
 sandpaper coarser than 320 grit.
 110 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB
 120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Folio FA087 2-File down transition lines
 smooth. 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card.
 FOLIO REV: _____ DWG REV: _____ *Do not use sandpaper coarser than 320 grit.
 130 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB
 140 - QC8 (QC8- Inspect parts - second check) QC8- Inspect parts - second check
 145 - Crosstubes-1 (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - Crosstubes-3 (Crosstubes) 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-
 TUBE INSIDE AND OUT. USE RED SCOTCH BRITE
 160 - QC7-1 (QC7-Inspect Chemical Conversion Coat) QC7-Inspect Chemical Conversion Coat
 170 - Identify and stock in kanban rack Location: _____
 180 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6002-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F107867

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6002-115	1	67	0

Part Specifications

Specifications could not be found.

DART
 AEROSPACE

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Container No: S191690



Part: D206-667-103TRN

Job No: 196495

Serial No/Batch: S191690

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/19/19

②

DART AEROSPACE LTD		Work Order: 196495
Description: Crosstube Assembly (206L High Fwd)		Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 2

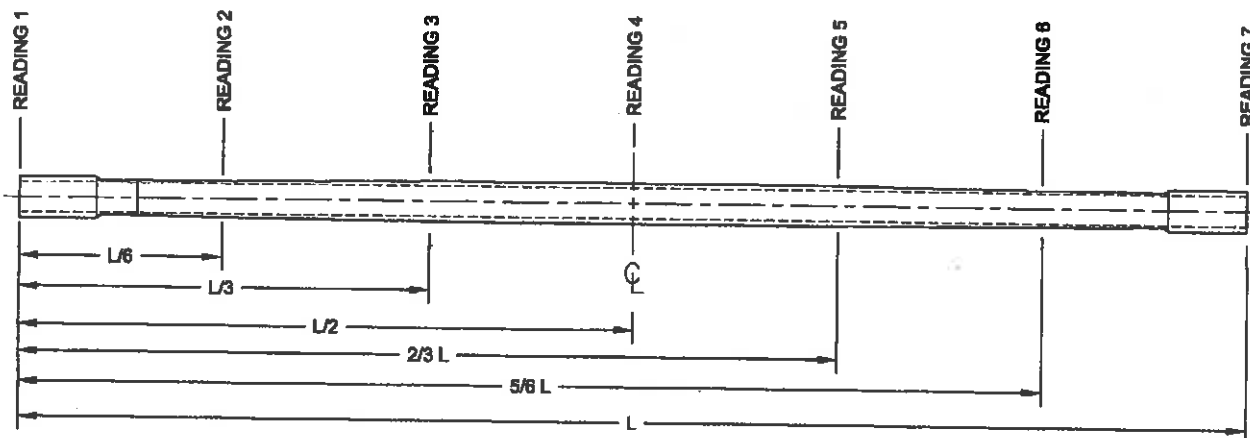
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	✓		CNC-04	
	1.982	+0.005/-0.000	1.985	✓		CNC-08	
	2.019	+0.005/-0.000	2.024	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.205	✓			
	0.125	+/-0.010	.116	✓		CNC-08	
	0.400 x 30°	+/-0.010					
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.437	✓		CNC-08	
SIDE B	104.98	+/-0.020	---	---	---	---	---
	2.240	+0.005/-0.000	2.240	✓		CNC-04	
	1.982	+0.005/-0.000	1.984	✓		CNC-08	
	2.019	+0.005/-0.000	2.023	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.205	✓			
	0.125	+/-0.010	.117	✓		CNC-08	
	0.400 x 30°	+/-0.010					
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.439	✓		CNC-08	
	104.984	+/- .030	105.00	✓		Tape	

2

DART AEROSPACE LTD	Work Order: 196495
Description: Crosstube Assembly (206L High Fwd)	Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: C	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE	Dwg	A
	w1	w2	w3	w4				
READING 1 L = 0"	247	262	249	227	.035	0.246	0.245	-0.018
READING 2 L = 17.497	169	181	174	151	-0.30	0.169	0.166	-0.015
READING 3 L = 34.995	245	257	240	219	.038	0.240	0.240	-0.021
READING 4 L = 52.492	250	266	253	226	.040	0.249	0.250	-0.024
READING 5 L = 69.989	241	262	246	214	.048	0.241	0.240	-0.020
READING 6 L = 87.487	163	187	179	141	.046	0.168	0.166	-0.025
READING 7 L = 104.984	246	265	249	222	.043	0.246	0.245	-0.023

Calibration Result

Actual Block Thickness: 100-300

Sitescan 250 Measured Thickness: 100-300

SiteScan 250 Measured Thickness: 100.3

Measured by: DAS 66		Audited by: DAS 67		Preliminary Approval:	
Date: 2019-06-20		Date: 19-07-25		Date:	

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	10.09.13	Dwg Rev updated	KJ	
D	12.06.04	Wall thickness form added	KJ	

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D8002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20801AD4WB	RIVET (OR NAS9302B-4-8)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9185-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

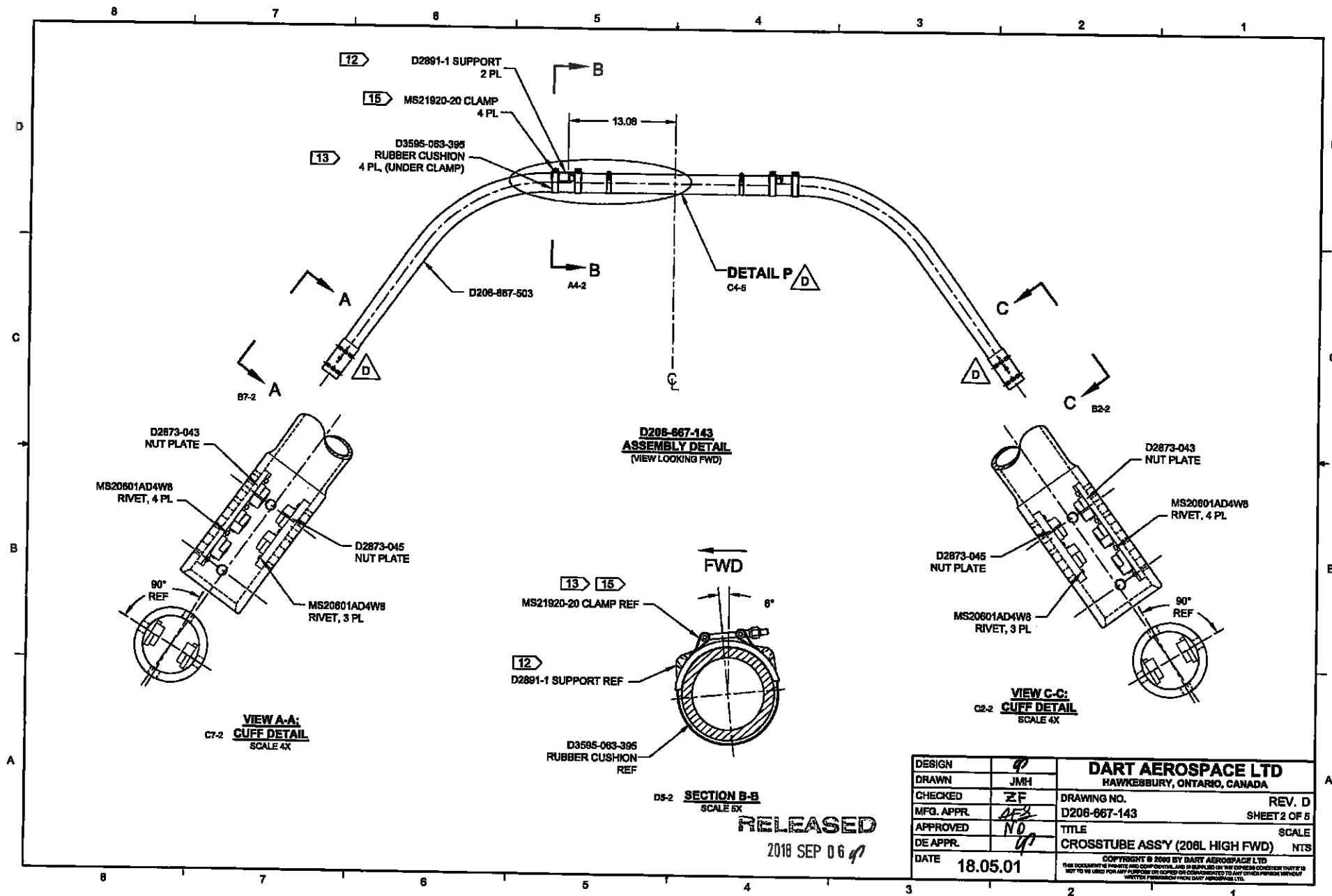
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D8002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 8% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MEGOHMS.

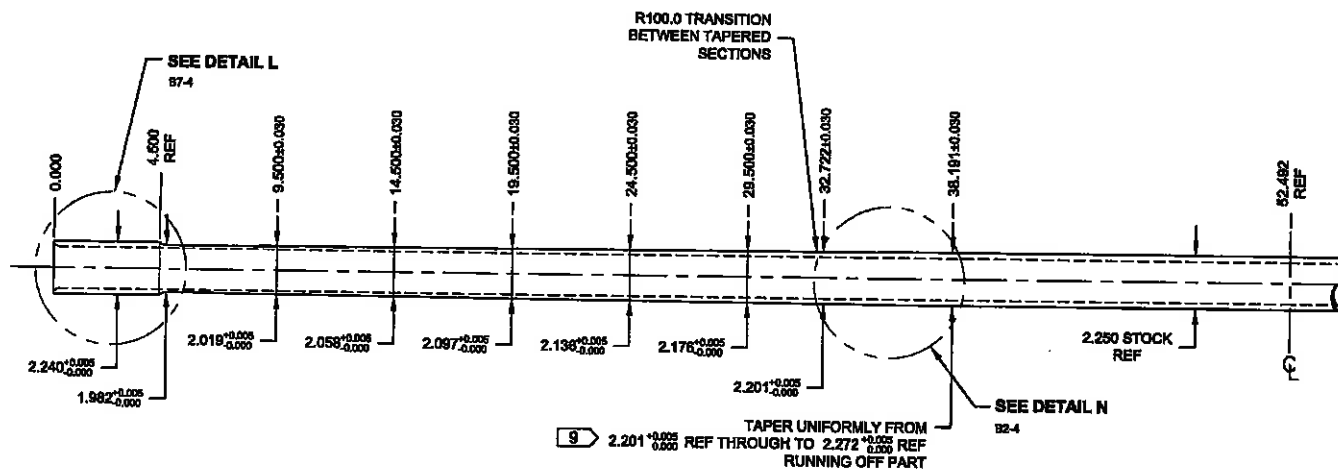
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196495 MJS
19-06-17

D	REVISE SHEET 2 ASSEMBLY DETAIL, HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO C-1. ADD ITEMS 10-14 TO PARTS LIST, ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO C-2.	JMH	18.05.01
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2858-400-894 (ZN D8-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHTAA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH		
CHECKED	EF		
MFG. APPR.	AFB		
APPROVED	N/D		
DE APPR.	4	DRAWING NO. D206-667-143	
DATE	18.05.01	TITLE	
		CROSSTUBE ASS'Y (206L HIGH FWD)	
		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE DISCLOSED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
		REV. D	
		SHEET 1 OF 5	
		SCALE	
		NTS	

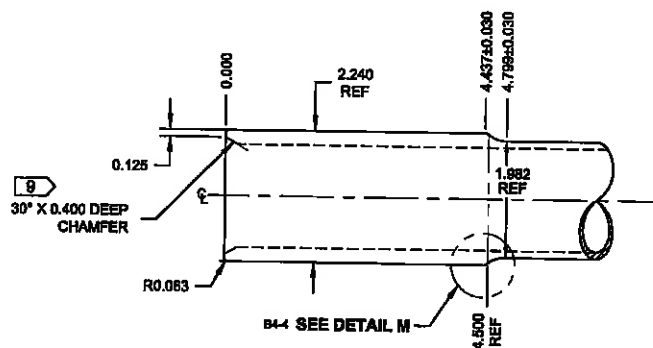
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ECN 14-747



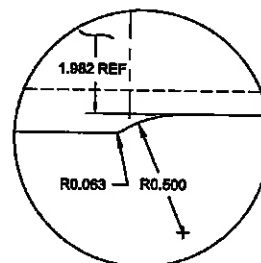
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH	DRAWING NO.	REV. D
CHECKED	ZF	D208-667-143	SHEET 2 OF 5
MFG. APPR.	AFB	TITLE	SCALE
APPROVED	NO	CROSSTUBE ASS'Y (208L HIGH FWD)	NTS
DE APPR.	JP	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
DATE	18.05.01	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



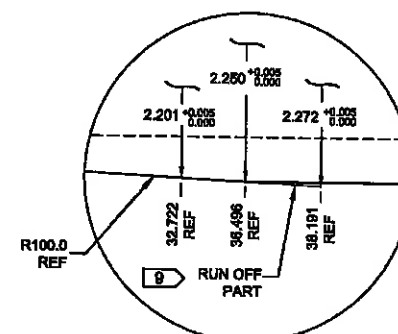
TURNING DETAIL



DETAIL L:
D7-4 **CROSSTUBE CUFF**
NOT TO SCALE



DETAIL M:
A6-4 **CUFF TRANSITION**
NOT TO SCALE

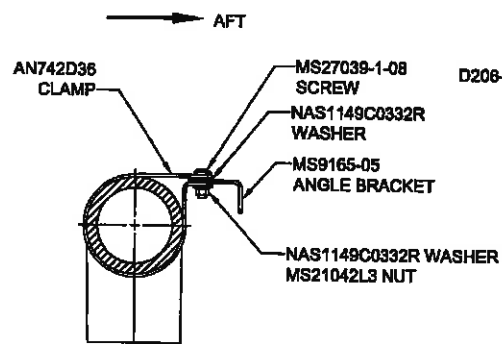


DETAIL N:
C4-4 **TAPER RUN-OFF**
NOT TO SCALE

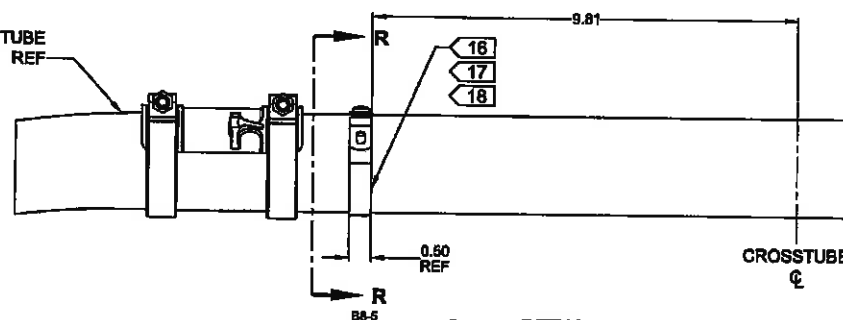
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2018 SEP 06

DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH	DRAWING NO.	REV. D
CHECKED	ZF	D208-887-143	SHEET 4 OF 5
MFG. APPR.	AFB	TITLE	SCALE
APPROVED	NO	CROSSTUBE ASS'Y (208L HIGH FWD)	NTS
DE APPR.	JP	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS TO BE USED ONLY FOR THE PURPOSES AND CONDITIONS STATED HEREIN. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	18.05.01		



D206-667-503 CROSTUBE
REF



BONDING STRAP INSTALLATION 2 PL

RELEASED
2018 SEP 06

DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-143	SHEETS OF 5
APPROVED	NB	TITLE	SCALE
DE APPR.	JP	CROSTUBE ASS'Y (206L HIGH FWD)	NTS
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Entered: 7/2 Date: 05/28/19



NCR No.

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>196495</u>		DISPOSITION		DEPARTMENT/PROCESS																															
Part No. <u>D206-667-1037RN</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☒ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐																												
Date: <u>2019-07-08</u>		Sequence #:		QTY Affected: <u>1</u>		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
Tube is eccentric after machining. Max ecc. is 0.026. Mean thickness is near nominal (-0.001) or thicker.				Ensure thin side is on neutral axis, ie. up-down in bender. Acceptable.																															
				Completed By: <u>[Signature]</u> Lead hand / Supervisor: <u>DAS 47 9-89</u> QC / QA Coordinator: <u>DAS 68 9-89</u> SEP 05 2019																															
Root Cause		FAULT CATEGORY																																	
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		<table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☒ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☒ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☒ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☒ Off-set/Set-up	
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